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(54) **SPACERS FOR INSULATED GLASS**

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CPC **E06B 3/67347** (2013.01); **E06B 3/66342** (2013.01); **E06B 3/6733** (2013.01)

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USPC 52/786.13, 172; 156/107, 109; 428/34
See application file for complete search history.

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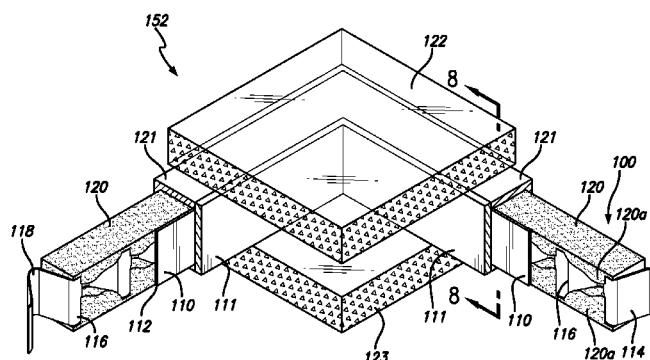
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(57) **ABSTRACT**

This invention provides a sealing spacer for spacing apart two window panes to form a window assembly. The spacer has an elongated, flexible strip having opposed edge surfaces and opposed side surfaces. The opposed edge surfaces undulate with crests and troughs. The spacer has an activatable sealant for directly sealingly securing the flexible strip to each of the two window panes. The activatable sealant is on each of the opposed side surfaces of the flexible strip, and extends into at least a portion of the opposed side surfaces of the flexible strip. The invention also provides methods for making the spacer and window assembly.

4 Claims, 10 Drawing Sheets



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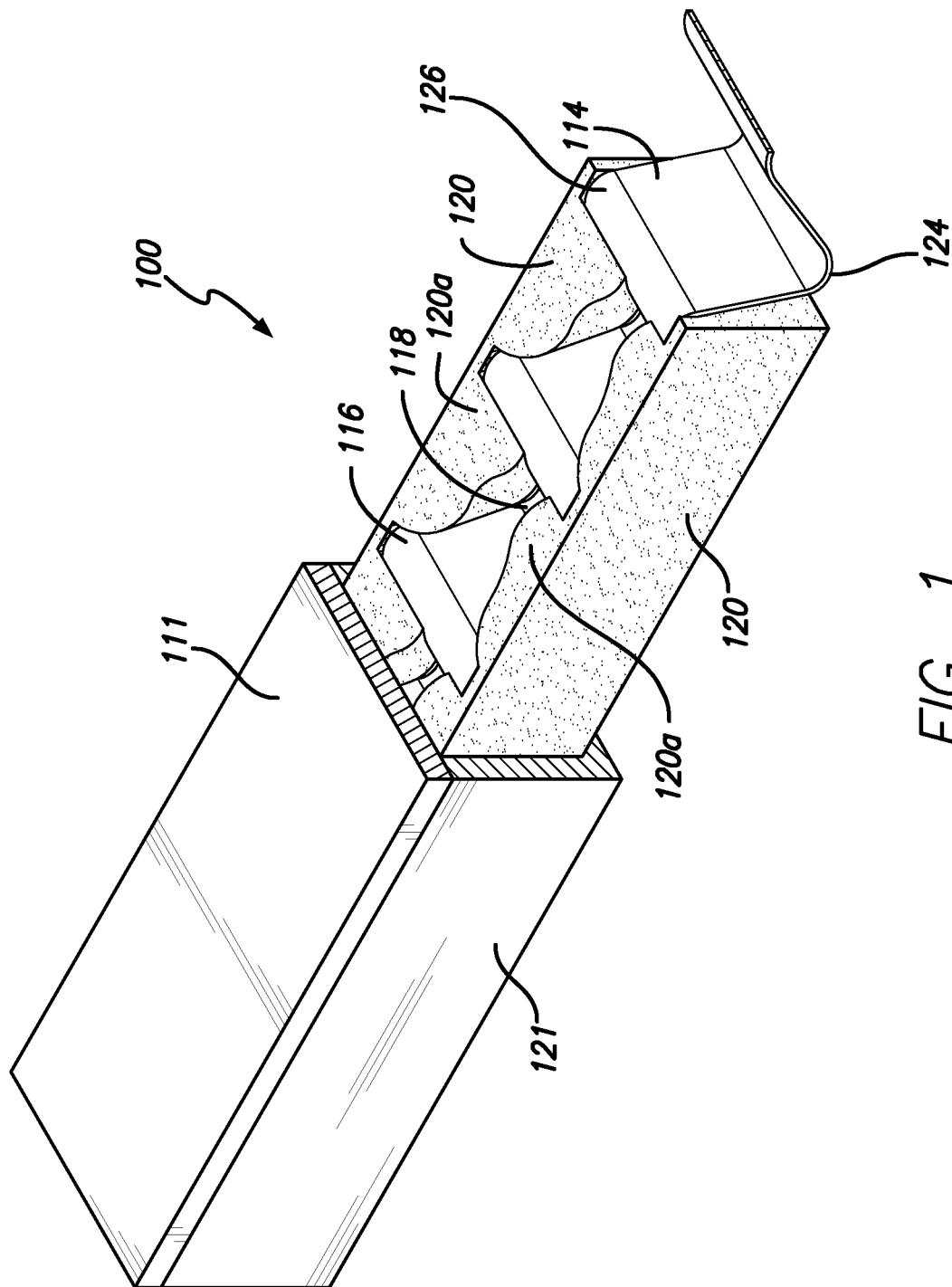


FIG. 1

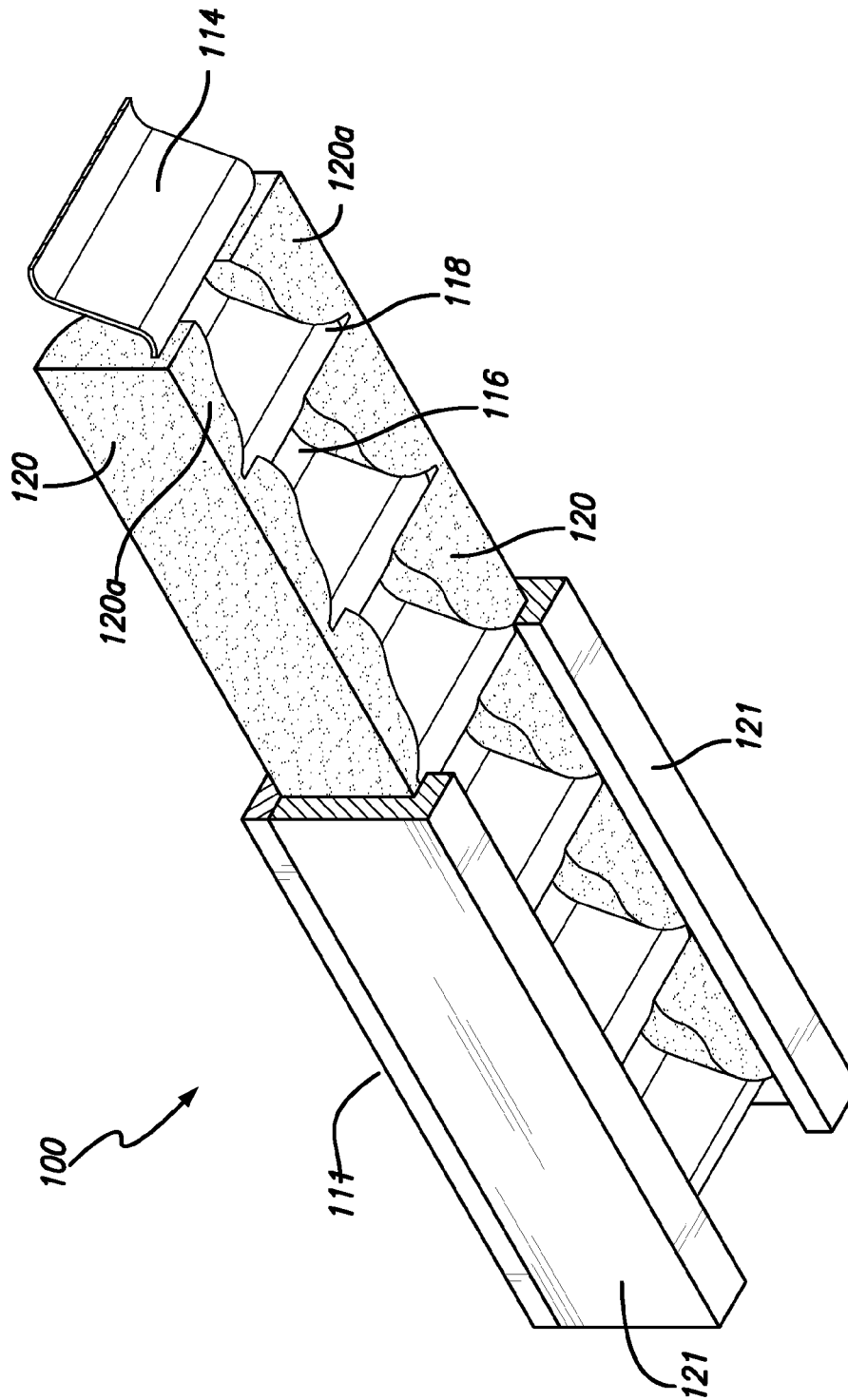


FIG. 2

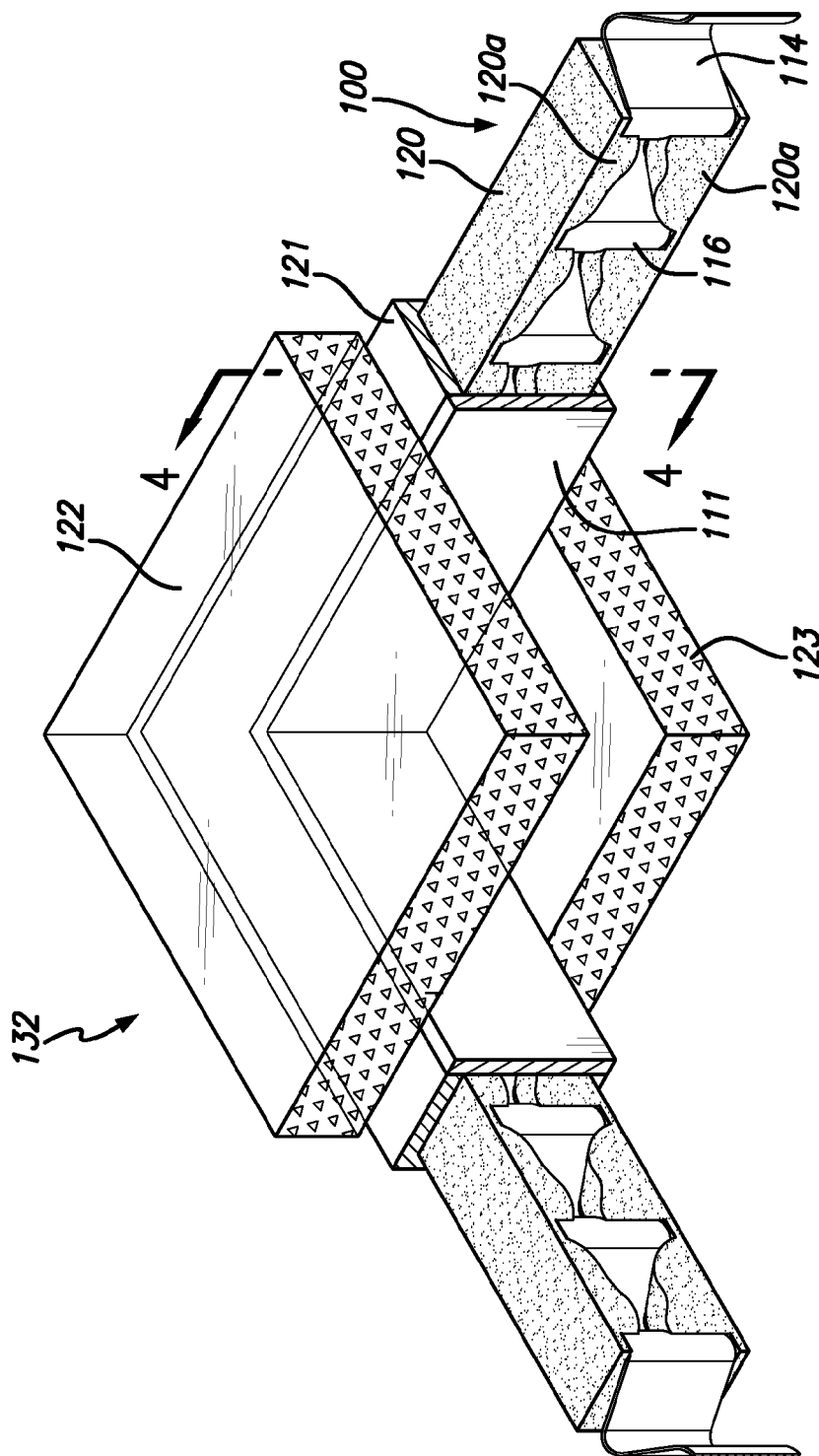


FIG. 3

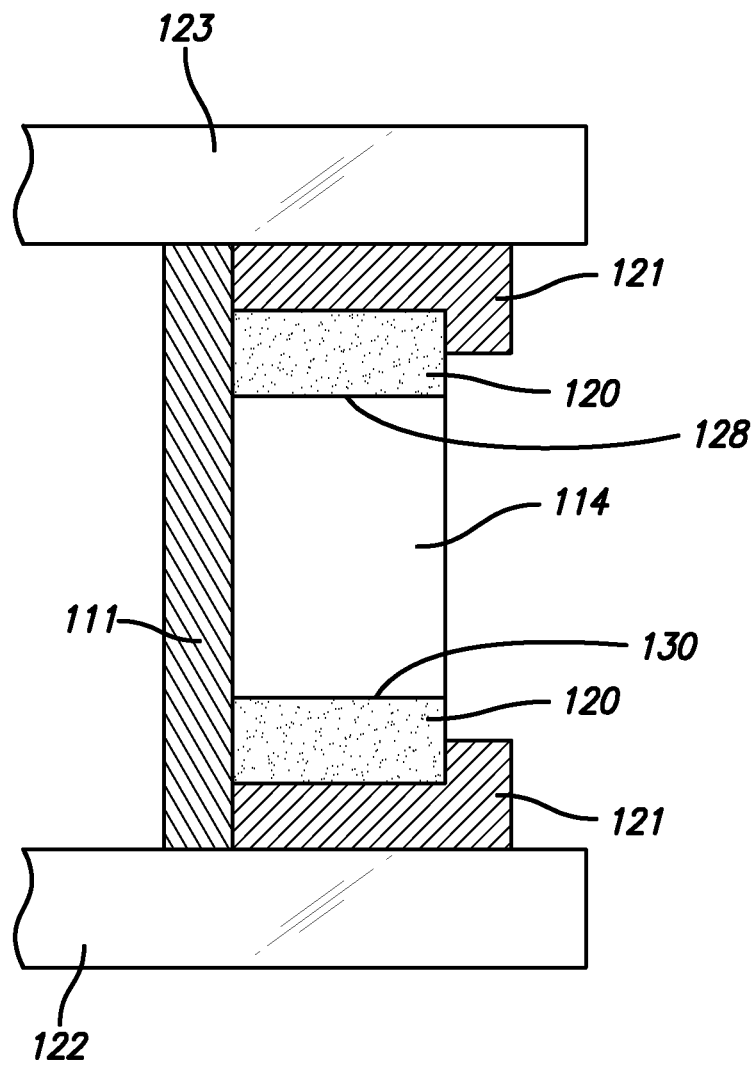


FIG. 4

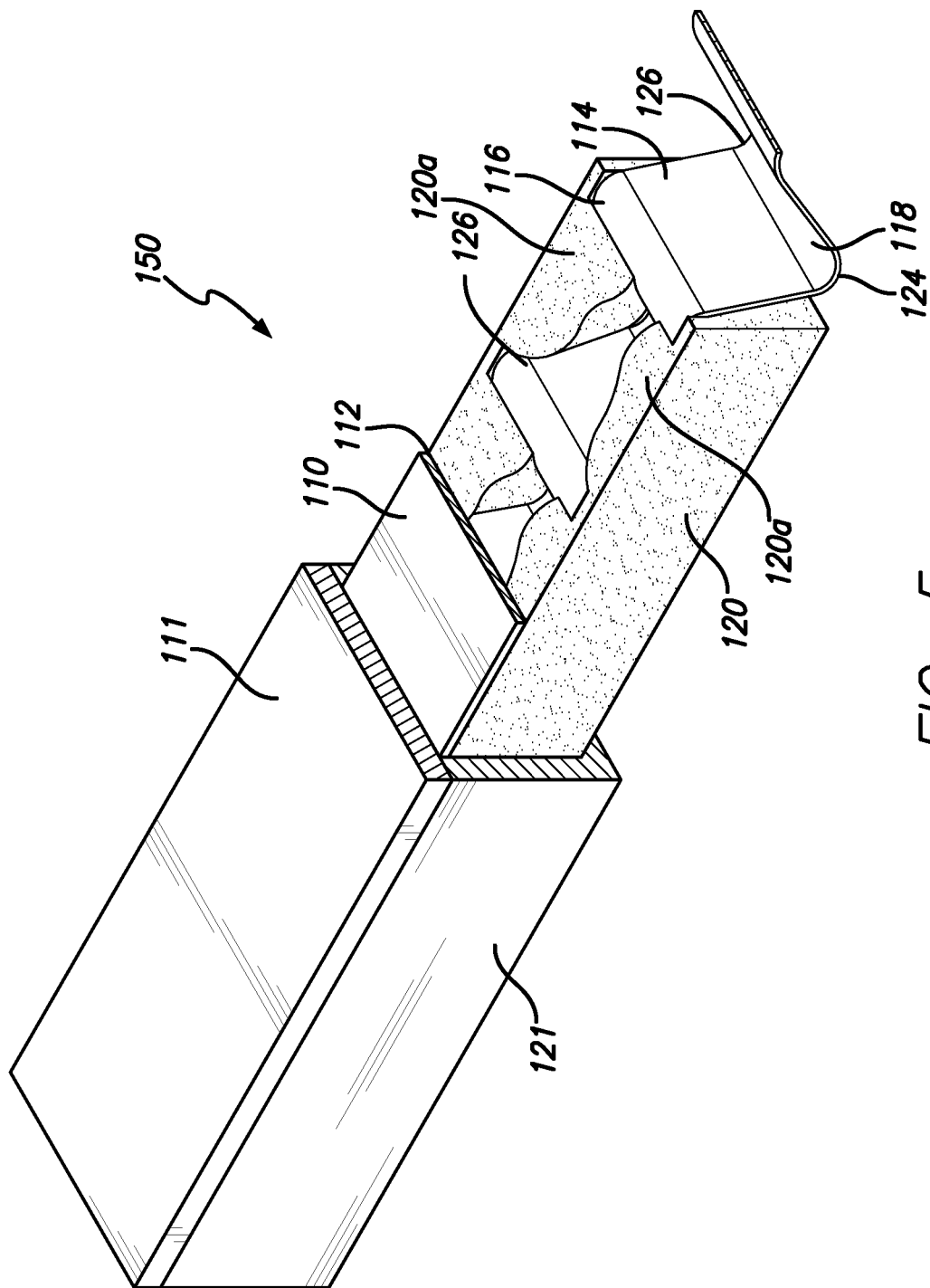


FIG. 5

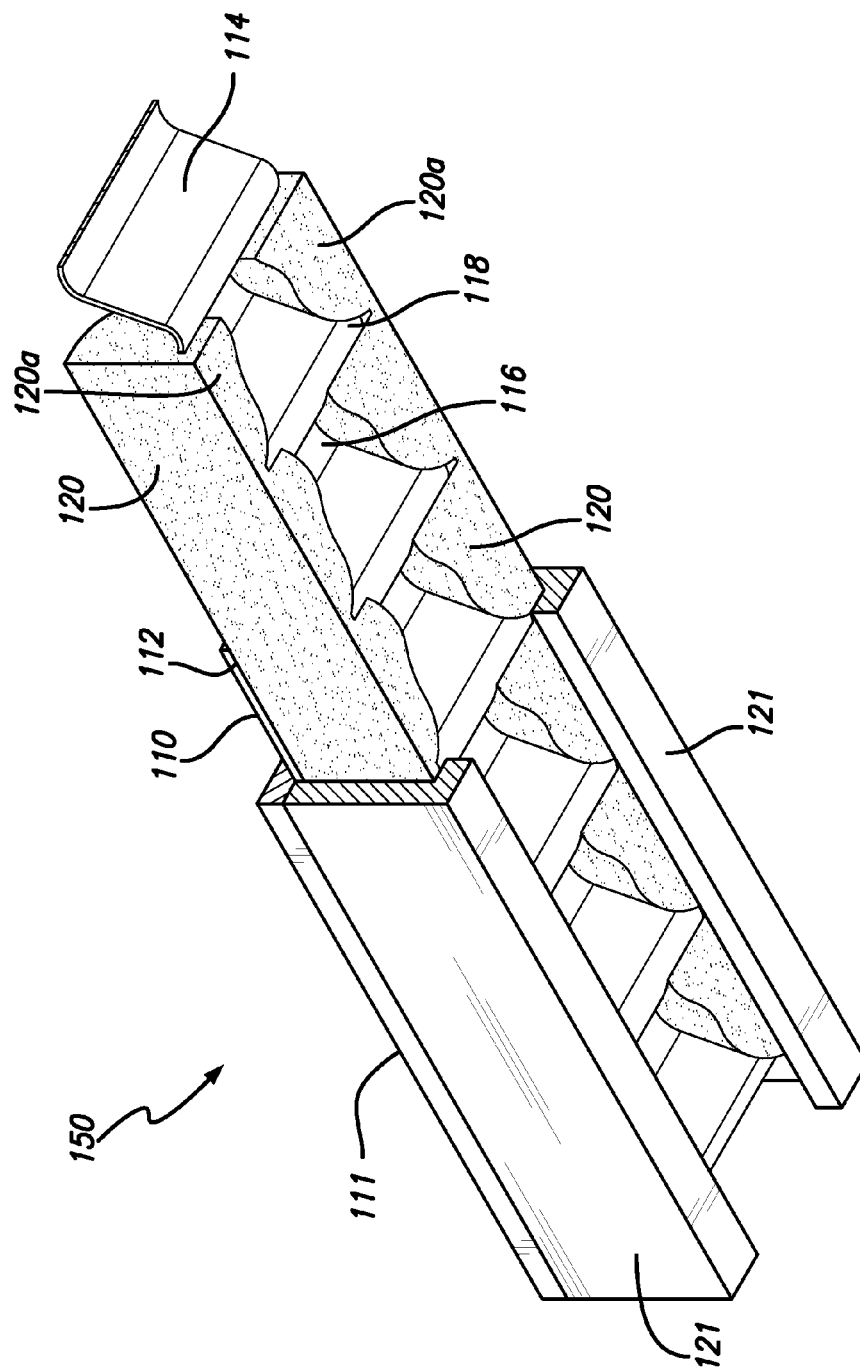


FIG. 6

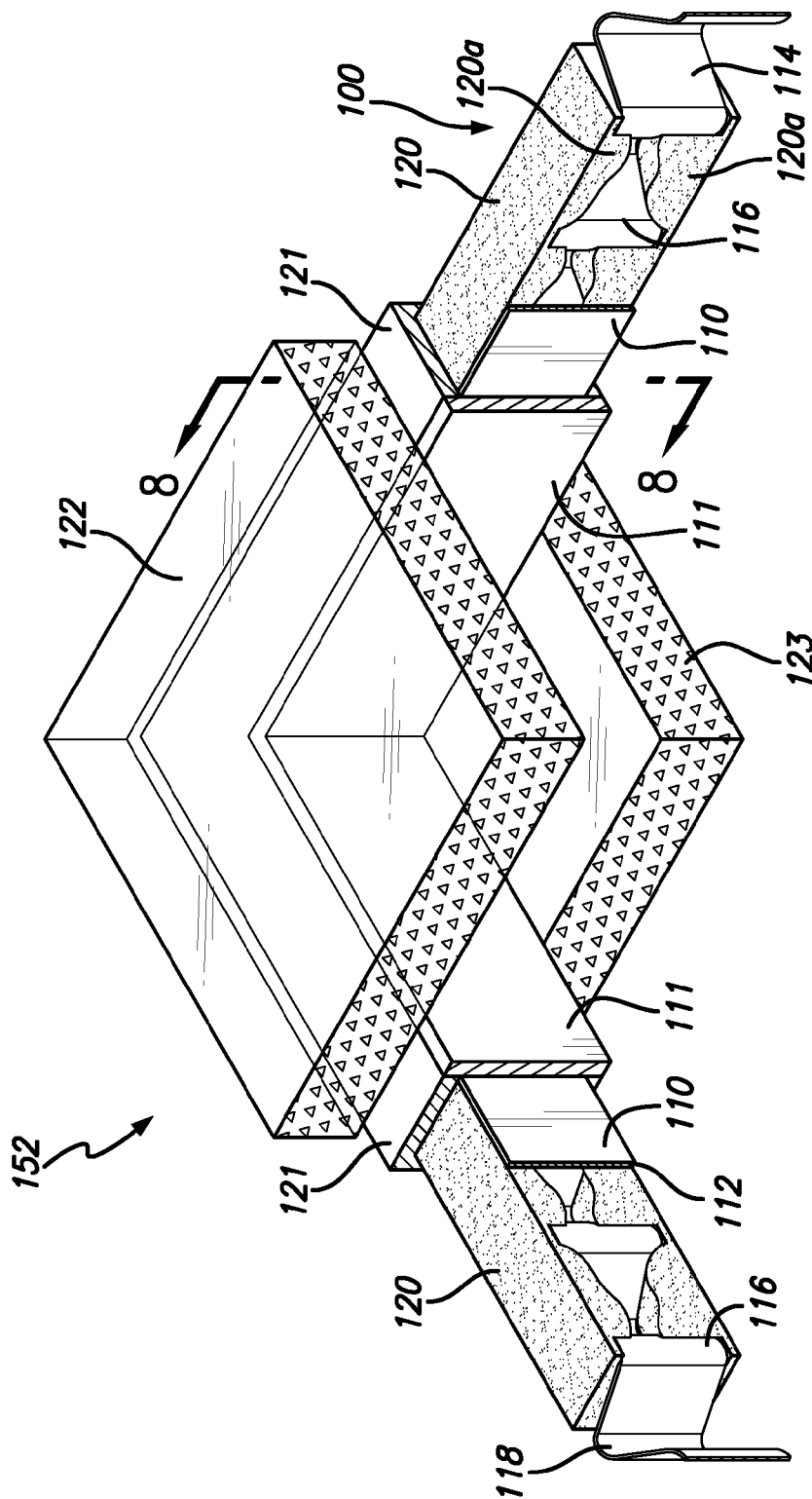


FIG. 7

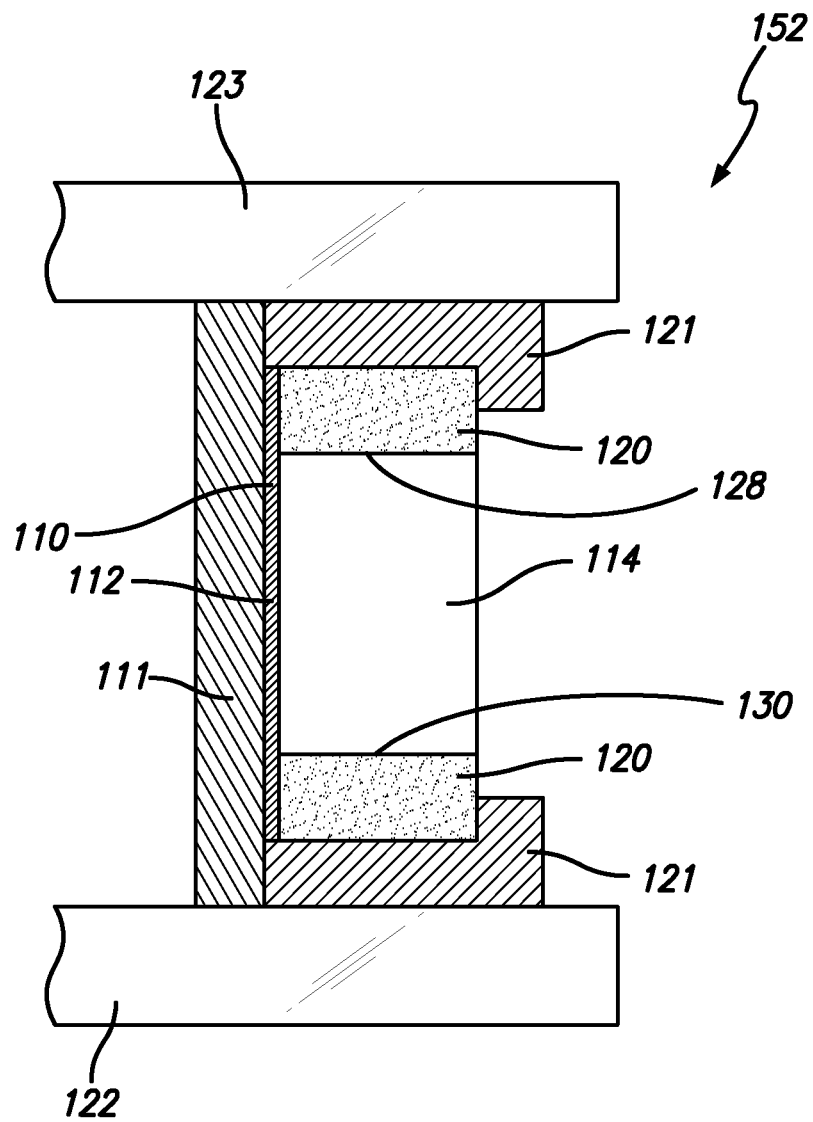


FIG. 8

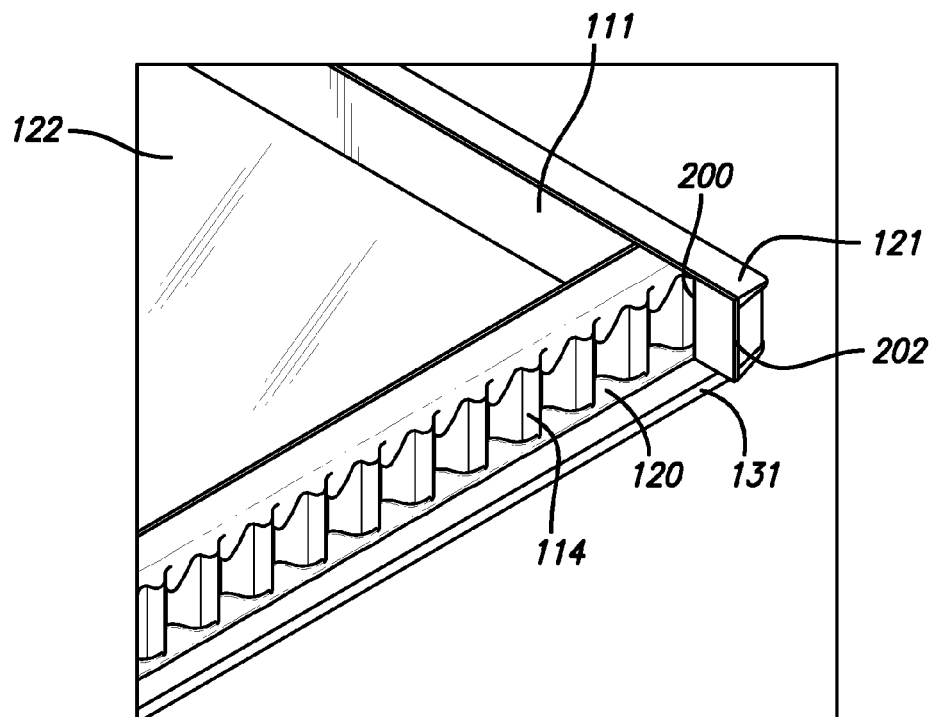


FIG. 9A

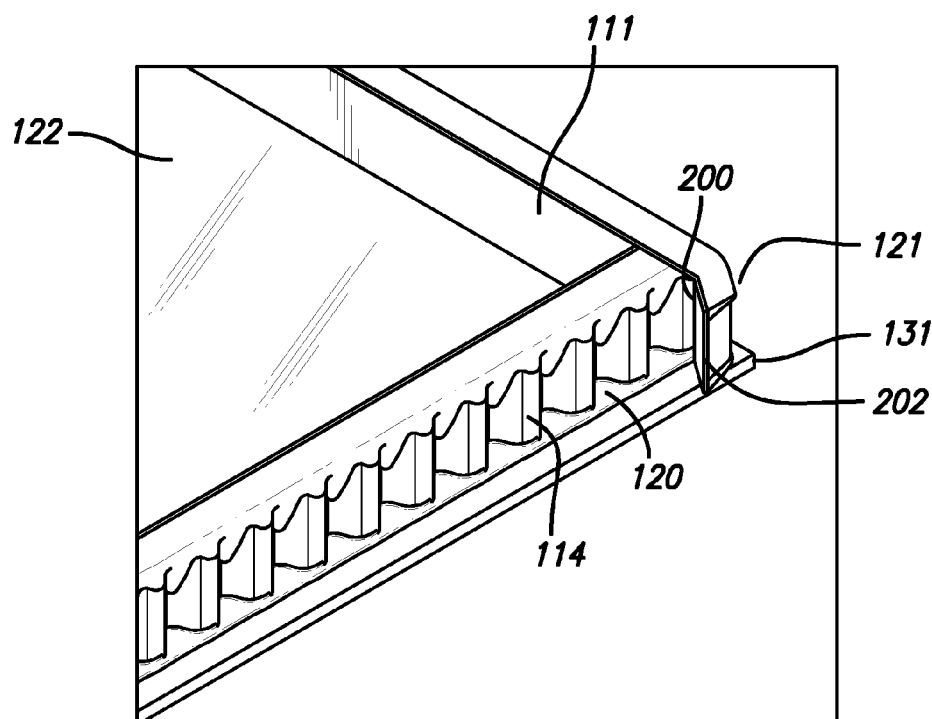


FIG. 9B

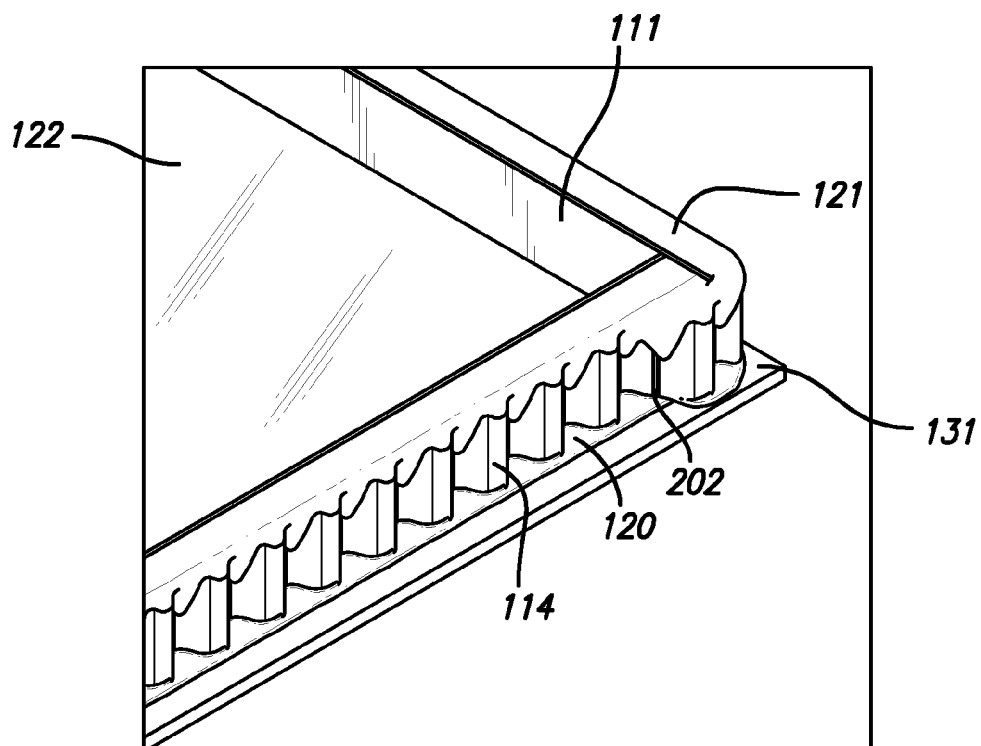


FIG. 9C

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SPACERS FOR INSULATED GLASS**CROSS-REFERENCE TO RELATED APPLICATION**

The present Application is a continuation of U.S. patent application Ser. No. 14/506,578 titled "Spacers for Insulated Glass" filed Oct. 3, 2014, which claims the benefit of U.S. Provisional Patent Application No. 62/005,748, titled "Spacers for Insulated Glass," filed May 30, 2014, the contents of which are incorporated in this disclosure by reference in their entirety.

BACKGROUND

Insulated windows are assembled by spacing two layers of glass in a fixed relationship. The layers of glass are fixed together at the outer edges of the glass with a removable or permanent spacer plus a sealant, or a structure that contains both a sealant and spacer. The layers of glass are sealed together, forming a sandwich structure that contains the sealant and/or spacer between the glass layers. There is also a sealed air pocket between the two glass layers.

The formation of a window assembly requires multiple steps when a removable spacer is used. First, the spacer must be placed between the glass layers. Second, the sealant is injected at the edges of the glass. Third, the sealant is cured. Fourth, the spacer is removed. This process is labor intensive and requires expensive equipment.

In contrast, when a permanent spacer is used, an adhesive is applied to secure the permanent spacer between the two pieces of glass. The spacer is then set in place, followed by injection of a sealant between the spacer and the edges of the sheets of glass. This process is also labor intensive.

An alternative method of manufacturing insulated windows uses a unitary structure containing both a sealant and spacer. Sealant and spacer structures that are currently used are made of a flexible, hollow metal material which has a support structure that is folded over the two edges and one side of the hollow metal material, as in U.S. Pat. Nos. 4,431,691 and 8,230,661. This support structure has many disadvantages, including increased manufacturing costs for materials and labor. Additionally, the presence of a support structure makes the spacer rigid and hard to bend to allow a 90 degree angle to be formed at the corners of a window assembly. Another disadvantage of spacers with a support structure is that there is no support within the hollow metal material, which may cause the spacer to fail when a lot of pressure is applied to the objects they are spacing apart.

SUMMARY

There is a need for a window assembly system with a spacer that functions as a unitary sealant and spacer for window panes without a support structure. This system has many advantages; for example, the spacer of the present invention costs less in materials and labor to manufacture, and allows for more flexibility in forming the corners of a window assembly.

The present invention is directed, in part, to a system containing a sealing spacer for spacing apart two window panes. The spacer has an elongated, flexible strip having opposed edge surfaces and opposed side surfaces which undulate with crests and troughs. The spacer also comprises an activatable sealant for directly sealingly securing the flexible strip to each of the two window panes, wherein the activatable sealant is on each of the opposed side surfaces of the flexible strip, and

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extends into at least a portion of the opposed side surfaces of the flexible strip. The activatable sealant extends from about 0.1 to about 4 mm into a portion of the opposed side surfaces of the flexible strip. Preferably, the activatable sealant extends at least about 1 mm into a portion of the opposed side surfaces of the flexible strip.

The spacer can also have a substantially flat strip adhered to the crests of one opposed edge surface of the flexible strip. The substantially flat strip can be metal such as aluminum. The substantially flat strip can also contain a desiccant.

The invention is also directed to a window assembly comprising two window panes sealingly secured by the spacer.

A method for forming a spacer for spacing apart two window panes is described, the method comprising the steps of (a) extruding an activatable sealant on a first and second opposed side surfaces of a flexible strip, (b) activating the activatable sealant, whereby the activation causes the activatable sealant to extend into at least a portion of the opposed side surfaces of the flexible strip, and (c) extruding a desiccant on one edge of the flexible strip. In one embodiment, the step of activating the activatable sealant comprises heating the activatable sealant to at least 70° C. and applying pressure of at least 0.1 kilograms per square meter. In another embodiment, the step of activating the activatable sealant comprises applying pressure of at least 0.1 kilograms per square meter to the activatable sealant. In yet another embodiment, the step of activating the activatable sealant comprises applying a temperature of at least 70° C. to the activatable sealant. In an additional embodiment, after step (b), a second portion of the activatable sealant is placed on the opposed side surfaces of the flexible strip in contact with the first portion of the activatable sealant.

The invention is also directed to a spacer for spacing apart two window panes comprising an elongated flexible strip having opposed edge surfaces and opposed side surfaces, wherein the opposed edge surfaces undulate with crests and troughs, and an activatable sealant for directly sealingly securing the flexible strip to each of the two window panes, wherein the activatable sealant is on each of the opposed side surfaces of the flexible strip, and extends into at least a portion of the opposed side surfaces of the flexible strip. A substantially flat strip is adhered to the crests of one edge surface of the flexible strip, and a layer of desiccant is adhered to the substantially flat strip. In one embodiment, the activatable sealant extends from about 0.1 to about 3 mm into the opposed side surfaces of the flexible strip. In another embodiment, the activatable sealant extends at least about 1 mm into the opposed side surfaces of the flexible strip.

The invention is also directed to a window assembly comprising a spacer assembly for spacing apart two window panes. The spacer assembly has an elongated flexible strip having opposed edge surfaces and opposed side surfaces, wherein the opposed edge surfaces undulate with crests and troughs, and an activatable sealant for directly sealingly securing the flexible strip to each of the two window panes. The activatable sealant is on each of the opposed side surfaces of the flexible strip, and extends into at least a portion of the opposed side surfaces of the flexible strip. The window assembly also has two window panes sealingly adhered to the opposed edge surfaces of the spacer by the activatable sealant. In one embodiment, the window panes comprise glass panes.

A method for making the window assembly is described. The method comprises the steps of placing a first side of a spacer on a first window pane, (b) placing a second window pane on a second side of the spacer, and (c) sealingly securing the first and second spacer sides to the first and second win-

dow pane by heating the sealant to at least 70° C. and applying pressure of at least 0.1 kilograms per square meter.

DRAWINGS

These and other features, aspects, and advantages of the present invention will become better understood with regard to the following description, appended claims, and accompanying drawings:

FIG. 1 is a partially broken top perspective view of a first version of a spacer having features of the present invention.

FIG. 2 is a partially broken bottom perspective view of a first version of a spacer having features of FIG. 1.

FIG. 3 is a partially broken perspective view of a first version of a spacer having features of FIG. 1 in a window assembly.

FIG. 4 is a cross sectional view of the window assembly of FIG. 3.

FIG. 5 is a partially broken top perspective view of a second version of a spacer.

FIG. 6 is a partially broken bottom perspective view of a second version of a spacer having features of FIG. 5.

FIG. 7 is a partially broken perspective view of a second version of a spacer having features of FIG. 5 in a window assembly.

FIG. 8 is a cross sectional view of the window assembly of FIG. 7.

FIGS. 9A-9C is a portion of the window assembly of FIG. 3 showing sequential steps for forming the window assembly.

DESCRIPTION

Definitions

As used herein, the following terms and variations thereof have the meanings given below, unless a different meaning is clearly intended by the context in which such term is used.

The terms “a,” “an,” and “the” and similar referents used herein are to be construed to cover both the singular and the plural unless their usage in context indicates otherwise.

An “activatable sealant” is a sealant that adheres to an object or elongated flexible strip or substantially flat strip by the application of pressure, elevated temperature, or a combination of pressure and elevated temperature.

As used herein, the term “comprise” and variations of the term, such as “comprising” and “comprises,” are not intended to exclude other additives, components, integers or steps.

A “desiccant” is a material that functions to minimize the effects of moisture. The desiccant prevents moisture from condensing on the interior surface of the window assembly. A desiccant can be part of the spacer, sealant, or spacer/sealant structure.

As used herein the term “sealingly secure” means an activatable sealant that is able to form an air-tight seal with a second material.

Spacer

The present invention is directed, in part, to a window assembly system containing a spacer for spacing apart transparent or translucent materials such as glass and plastic window panes.

In contrast to spacers used in prior window assemblies, the spacer of the present invention functions as a unitary sealant and spacer without the need for a support structure. The present invention has many advantages over the currently used spacers; for example, the spacer of the present invention costs less in materials and labor to manufacture, and allows for more flexibility in forming the corners of a window assembly.

FIGS. 1 and 2 depict a spacer **100** comprising an elongated, flexible strip **114** having an opposed first edge surface **124** and a second edge surface **126** which undulates with crests **116** and troughs **118**. The flexible strip also has an opposed first side surface **128** and second side surface **130**. FIGS. 3 and 4 depict a window assembly **132** wherein the spacer **100** is used to space apart a first window pane **122** and a second window pane **123**.

The first and second side surfaces **128**, **130** of the flexible strip **114** are rigid in order to resist compressive forces from the window panes **122**, **123**, while the edge surfaces **124**, **126** are sufficiently flexible to bend. The flexible strip **114** can be made of any rigid material, such as, for example, plastic such as polycarbonate (PC) or polyethylene terephthalate (PET), or a metal such as aluminum.

The spacer **100** also comprises an activatable sealant **120** for directly sealingly securing the flexible strip **114** to each of the two window panes, wherein the activatable sealant **120** completely covers the opposed side surfaces **128**, **130** of the flexible strip **114**, as shown in FIGS. 1 and 2. An advantage of having an activatable sealant **120** which completely covers the side surfaces **128**, **130** of the flexible strip **114** is that there is better contact between the activatable sealant **120** and the flexible strip **114**, which increases the overall stability of the spacer **100** when it is used to space apart two window panes **122**, **123**.

Suitable materials for the activatable sealant **120** can be, for example, a polymer, a resin, or synthetic rubber. Preferably, the activatable sealant **120** is butyl rubber.

The thickness of the activatable sealant **120** on the side surfaces **128**, **130** of the elongated flexible strip **114** preferably is sufficient to maintain a continuous seal between the spacer **100** structure and the two window panes **122**, **123**. However, the activatable sealant **120** cannot be so thick that it causes substantial distortion of the spacer **100** under applied compressive forces. There is also an extended sealant section **120a** which extends from the periphery of the side surfaces **128**, **130**, at least towards the middle of the flexible strip **114**. An advantage of having an activatable sealant **120a** which extends towards the middle of the flexible strip **114** is better adhesion between the spacer **100** and the first and second window panes **122**, **123**.

The extended sealant section **120a** extends from about 0.1 to about 4 mm from the periphery of the side surfaces **128**, **130** at least towards the middle of the flexible strip **114**. Preferably, the thickness of the extended sealant section **120a** from the periphery of the side surfaces **128**, **130** towards the middle of the flexible strip **114** is from about 1 mm to about 2 mm. More preferably, the extended sealant section **120a** extends at least about 1 mm from the side surfaces **128**, **130** towards the middle of the flexible strip **114**.

The spacer **100** can also contain a desiccant **111** adhered to the second edge surface **126** of the elongated flexible strip **114**. The desiccant **111** removes moisture and optionally organic material from the space between the first and second window panes **122**, **123**. The desiccant can be, for example, silica, activated charcoal, calcium sulfate, calcium chloride, molecular sieves, or a combination of one or more desiccants.

It is also contemplated that the window assembly system has a second version of a spacer **150**, as shown in FIGS. 5-8. The second version of the spacer **150** is similar to the first version of the spacer **100**, with the addition of a substantially flat strip **110** adhered to the extended sealant section **120a** and the crests **116** of the second edge surface **126** of the flexible strip **114**. The substantially flat strip **110** can be made out of any rigid material such as metal. A metal that can be used is,

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for example, aluminum. The substantially flat strip **110** can also contain a desiccant **111** adhered to the substantially flat strip **110**.

Method of Making the Spacer

The invention is also directed to a method for making the spacer **100** or second version of the spacer **150** described above. In one aspect, the method can be a one-step method for forming the spacer **100** or second version of the spacer **150**. In another aspect, the method can be a two-step method for forming the spacer **100** or second version of the spacer **150**.

For the one-step method, an activatable sealant **120**, such as, for example, a hot melt sealant butyl rubber, is extruded by an extruder on the two opposed side surfaces **128**, **130** of the flexible strip **114**. The activatable sealant **120** is then activated to allow the sealant to flow into the troughs **118** and crests **116** of the flexible strip **114**, extending as an extended sealant section **120a** from the periphery of the side surfaces **128**, **130**, at least towards the middle of the flexible strip **114**.

Activating the activatable sealant **120** comprises applying pressure and/or heat to the activatable sealant **120**. The pressure applied to the activatable sealant **120** is at least 0.1 kilogram per square meter, and the temperature applied is at least 70° C. The activatable sealant **120** is then cooled to room temperature.

Simultaneously with the extrusion of the activatable sealant **120** on the two opposed side surfaces of the elongated flexible strip **114**, the desiccant **111** is extruded on top of and adhered to the edge surface of the flexible strip **114**. During extrusion, the temperature of the extruder is 80° C. to 90° C. After extrusion, the spacer is cooled to room temperature.

For the second version of the spacer **150**, a substantially flat strip **110** is adhered to the crests **116** of the second edge surface **126** of the flexible strip **114** with an adhesive **112**. An adhesive **112** can be any material that allows the substantially flat strip **110** to adhere to the flexible strip **114**. For example, the adhesive **112** can be hot melt sealant butyl rubber.

Next, the flexible strip **114** is placed on the adhesive **112**, joining the substantially flat strip **110** to the second edge surface **126** of the flexible strip **114**. A pressure of between 0.5 and 1.0 kilograms per square meter is applied to the substantially flat strip **110**/flexible strip **114** structure to allow the structure to adhere. The activatable sealant **120** can be applied either before or after the substantially flat strip **110**/flexible strip **114** structure is formed.

Another aspect of the invention is a two-step method for forming the spacer **100** or second version of the spacer **150**. The method includes the steps of the one-step method above, with the following additional steps. After the first portion of the activatable sealant **120** is allowed to cool, a second portion of the activatable sealant **121** is extruded by an extruder on the two opposed side surfaces **128**, **130** of the flexible strip **114** in contact with the first portion of the activatable sealant **120**. In one embodiment, the first portion of the activatable sealant **120**, is joined to the second portion of the activatable sealant **121** by applying pressure and/or heat to the spacer **100** or second version of the spacer **150**.

Simultaneously with the extrusion of the second portion of activatable sealant **121**, the desiccant **111** is adhered to the surface of the substantially flat strip **110** as described above. During extrusion, the temperature of the extruder is 80° C. to 90° C. After extrusion, the spacer **100** or second version of the spacer **150** is cooled to room temperature.

Window Assembly and Method of Making

The spacer **100** or second version of the spacer **150** described above can be placed between two or more objects in order to space the objects apart and make an assembly such as, for example, a window assembly **132** or **152**. In the window

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assembly **132** or **152**, a first window pane **122** and second window pane **123** are spaced apart by the spacer **100**, as shown in FIG. 4, or second version of the spacer **150**, as shown in FIG. 5.

The first and second window panes **122**, **123** can be any surfaces that are made out of a material such as glass, plastic, or Plexiglas. The window panes **122**, **123** can be made out of the same material or different material. In one embodiment, the window panes **122**, **123** spaced apart by the spacer **100** or second version of the spacer **150** are glass panes.

The orientation of the spacer **100** is such that the side surfaces **128**, **130** of the flexible strip **114** come into contact with the window panes **122**, **123**. The spacer **100** is able to resist substantial compressive forces exerted upon it in a direction perpendicular to the surface of the window panes **122**, **123**. As shown in FIGS. 4 and 8, the desiccant **111** is oriented towards the inside of the window assembly **132** or **152**.

The invention includes a method for forming a window assembly **132** or **152** comprising a spacer **100** and two window panes **122**, **123** sealingly adhered to the opposed side surfaces **128**, **130** of the spacer **100** or second version of the spacer **150** by the activatable sealant **120**. The method comprises placing the spacer **100** or second version of the spacer **150** between the two window panes **122**, **123**, adhering the spacer **100** or second version of the spacer **150** to the two window panes **122**, **123** by heating the activatable sealant to at least 70° C. and/or applying pressure of at least 0.1 kilograms per square meter.

FIGS. 9A-9C depict the method used to form a window assembly **132**. In order to form the continuous spacer **100** at a corner **131** of the window assembly **132**, a first end **200** of the spacer **100** is placed on one corner of the first window pane **122**. The spacer **100** is then placed around the four sides and three edges of the first window pane **122** until a second end **202** of the spacer **100** extends past the first end **200** of the spacer **100**, as shown in FIG. 9A. The second end **202** of the spacer **100** is then folded on top of the first end **200** of the spacer **100** as shown in FIG. 9B. Pressure is applied to the overlapping ends of the spacer **100**, sealingly adhering the spacer **100** to itself.

The second window pane **123** is then placed on top of the first substantially parallel pane **122** and spacer **100**, forming a sandwich structure. To ensure that the first and second substantially parallel panes **122**, **123** and the spacer **100** are adhered securely together, pressure and/or temperature is then applied to the entire window assembly **132**. In the window assembly **132**, the space between the window panes **122**, **123** is sealed from the atmosphere, and the air can be removed from the space. A gas such as argon can be introduced in the space between the window panes **122**, **123**.

The method of assembling a glass window assembly **132** can be used to manufacture new or replacement windows with two or more panes of glass. A triple-paned glass window assembly can also be made by repeating the steps above with a second spacer **100** and a third window pane.

EXAMPLE

A spacer was manufactured using the following method. First, hot melt butyl rubber was extruded on the surface of the substantially flat strip made of aluminum metal using an extruder at 74° C., and a die at 176° C.

Second, the flexible strip, made out of corrugated aluminum, was placed on the butyl rubber on the substantially flat

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strip. A pressure of between 0.5 and 1.0 kilograms per square meter was applied to the substantially flat strip/butyl rubber/flexible strip structure.

Third, hot melt butyl rubber was extruded into the two opposed side surfaces of the flexible strip and into the interstitial spaces of the flexible strip made by the crests and troughs of the flexible strip.

The activatable sealant was adhered to the entire side surface of the flexible strip and extended into the interstitial spaces of the flexible strip at a distance of approximately 2-3 mm from the side of the flexible strip using an extruder at 74° C., and a die at 176° C. After extrusion, the spacer was cooled to 28° C.

After cooling, hot melt butyl rubber was extruded on one edge surface of the elongated flexible strip/butyl rubber structure using an extruder at 82° C., and a die at 155° C.

Simultaneously with the extrusion of the butyl rubber on the edge of the flexible strip, a desiccant was extruded on top of and adhered to the surface of the substantially flat aluminum strip using an extruder at 83° C., and a die at 183° C. After extrusion, the structure was cooled to 35-38° C.

Although the present invention has been discussed in considerable detail with reference to certain preferred embodiments, other embodiments are possible. Therefore, the scope of the appended claims should not be limited to the description of preferred embodiments contained in this disclosure.

What is claimed is:

1. A method for forming a spacer for spacing apart two window panes, the method comprising the steps of:

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(a) adhering an inner surface of a substantially flat strip to an elongated strip having opposed side surfaces and interstitial spaces;

(b) extruding a first activatable sealant on the opposed side surfaces of an elongated strip, wherein the first activatable sealant extends into at least a portion of the interstitial spaces of the elongated strip;

(c) activating the first activatable sealant, whereby the activation causes the first activatable sealant to extend into the at least a portion of the interstitial spaces of the elongated strip;

(d) after step (c), extruding a second activatable sealant for directly sealingly securing the elongated strip to each of the two window panes, the second activatable sealant being in contact with the first activatable sealant, wherein the second activatable sealant is applied separately from the first activatable sealant; and

(e) extruding a desiccant on one edge surface of the substantially flat strip.

2. The method of claim 1, wherein step of activating the first activatable sealant is by heating the first activatable sealant to at least 70° C. and applying pressure of at least 0.1 kilograms per square meter.

3. The method of claim 1, wherein the step of activating the first activatable sealant comprises applying pressure of at least 0.1 kilograms per square meter to the first activatable sealant.

4. The method of claim 1, wherein the step of activating the first activatable sealant comprises applying a temperature of at least 70° C. to the first activatable sealant.

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